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THE UNITED STATES OF AMERICA

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APPLICATION THAT MET THE REQUIREMENTS TO BE GRANTED A
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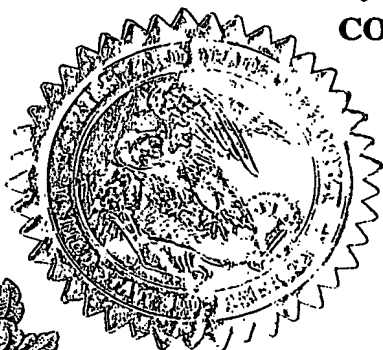
APPLICATION NUMBER: 10/273,357

FILING DATE: October 18, 2002

**PRIORITY
DOCUMENT**

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**By Authority of the
COMMISSIONER OF PATENTS AND TRADEMARKS**



L. Wallace
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Certifying Officer

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

REQUEST FOR FILING APPLICATION

Under Rule 53(a), (b) & (f)

(No Filing Fee or Oath/Declaration)

(Do NOT use for Provisional or PCT Applications)

Use for Design or Utility Applications

PATENT
APPLICATION

RULE 53(f) NO DECLARATION

Hon. Commissioner of Patents
Washington, DC 20231

Atty. Dkt.

P 0292983

M#

D1229

Client Ref.

Date:

October 18, 2002

Sir:

1. This is a Request for filing a new Patent Application (☐ Design ☒ Utility) entitled:2. (Complete) Title: **CURABLE COMPOSITIONS AND RAPID PROTOTYPING PROCESS USING THE SAME**

without a filing fee or Oath/Declaration but for which is enclosed the following:

3. ☒ Abstract 1 page(s).4. 25 Pages of Specification (only spec. and claims); 5. ☐ Specification in non-English language6. 31 Numbered claim(s); and7. ☐ Drawings: sheet(s) ☐ 1 set informal; 8. ☐ formal of size: ☐ A4 ☐ 11"9. **DOMESTIC/INTERNATIONAL** priority is claimed under 35 USC 119(e)/120/365(c) based on the following provisional, nonprovisional and/or PCT international application(s):

| Application No. | Filing Date | Application No. | Filing Date |
|-----------------|-------------|-----------------|-------------|
| (1) | | (2) | |
| (3) | | (4) | |
| (5) | | (6) | |

10. **FOREIGN** priority is claimed under 35 USC 119(a)-(d)/365(b) based on filing in

| Application No. | Filing Date | Application No. | Filing Date |
|-----------------|-------------|-----------------------------------------------------------------------------|-------------|
| (1) | | (2) | |
| (3) | | (4) | |
| (5) | | <input type="checkbox"/> See 3 rd page for additional priorities | |

11. (No.) Certified copy (copies): ☐ attached; ☐ previously filed (date)
in U.S. Application No. / filed on 12. ☐ This is a reissue of Patent No. 13. ☐ See top first page re prior Provisional; National, International application(s) (X box only if info is there and do not complete corresponding item 14 or 15.)14. ☐ Amend the specification by inserting before the first line -- This is a ☐ Continuation-in-Part of:
☐ Divisional ☐ Continuation ☐ Substitute Application (MPEP 201.09)14(a) ☐ National Appln. No. / filed -- (M#)14(b) ☐ International Appln. No. PCT/ filed which
designated the U.S., and that International Application ☐ was ☐ was not published
under PCT Article 21(2) in English.--15. ☐ Amend the specification by inserting before the first line: --This application
claims the benefit of U.S. Provisional Application No. 60/ , filed --16. Extension to date: ☐ concurrently filed ☐ not needed ☐ previously filed17. ☐ Small Entity Status is claimed (**pre-filing confirmation required**)17(a) ☐ Attached: (No.) Small Entity Statement(s). (Since 9/8/00 Small Entity Statement **not**
essential to make claim)17(b) ☐ See **NONPUBLICATION REQUEST** under Rule 213(a) attached (PAT-258)

18. ☐ Prior application is assigned to

by Assignment recorded _____ Reel _____ Frame _____

19. ☐ Attached:

20. This application is made by the following named inventor(s) (Double check instructions for accuracy.):
(Listing of inventor(s) not a requirement, but list if known)

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21. NOTE: FOR ADDITIONAL INVENTORS, check box ☐ and attach sheet with same information regarding additional inventors.

BEST AVAILABLE COPY

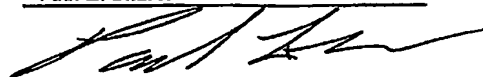
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NOTE: File in duplicate with 2 post card receipts (PAT-103) & attachments

CURABLE COMPOSITIONS AND RAPID PROTOTYPING PROCESS USING THE SAME

FIELD OF THE INVENTION

- 5 The present invention relates to curable compositions capable of providing articles having the combination of a good elongation at break and good high temperature resistance. In addition, the present invention relates to applications for such compositions, such as their use in rapid prototyping processes.

10 BACKGROUND

- In the field of curable compositions, for instance in the field of rapid prototyping compositions, high temperature resistance, elongation to break, and cure speed are relevant parameters. Unfortunately, a composition providing good high temperature resistance often exhibits a poor elongation to break. One of the objectives of the present invention is to
- 15 provide compositions yielding both a good high temperature resistance and a good elongation to break. Another objective is to provide compositions that furthermore have a good cure speed.

- Examples of prior curable compositions are set forth in, for instance, U.S. Patent 5,476,748;
- 20 U.S. Patent 5,707,780; U.S. Patent 5,972,563; U.S. Patent 5,981,616; U.S. Patent 6,313,188; U.S. Patent 6,368,769; European Patent Application 0360869; and Japanese Patent Application 11199647.

SUMMARY

- 25 The present invention provides compositions having both a good high temperature resistance and a good elongation to break. Furthermore, the present invention provides compositions that additionally have a good cure speed. Also, the present invention provides applications for the compositions, such as their use in a rapid prototyping process.
- 30 In one embodiment, the present invention provides a curable composition comprising:
- (i) one or more aromatic epoxies; and
 - (ii) one or more aliphatic epoxies;

wherein said composition, after full cure, has a heat deflection temperature under a pressure of 1.82 MPa of at least 105°C and an elongation at break of at least 1.5%.

In another embodiment, the present invention provides a curable composition having an E10
5 cure speed of less than 80 mJ/cm² and, after full cure, a heat deflection temperature under a pressure of 1.82 MPa of at least 125°C and an elongation at break of at least 2.5%.

Additional objects, advantages and features of the present invention are set forth in this specification, and in part will become apparent to those skilled in the art on examination of
10 the following, or may be learned by practice of the invention. The inventions disclosed in this application are not limited to any particular set of or combination of objects, advantages and features. It is contemplated that various combinations of the stated objects, advantages and features make up the inventions disclosed in this application.

15 DETAILED DESCRIPTION

(A) *Cationically curable component*

The present compositions comprise at least one cationically curable component, *e.g.* at least one cyclic ether component, cyclic lactone component, cyclic acetal component, cyclic thioether component, spiro orthoester component, epoxy-functional component, and/or
20 oxetane-functional component. Preferably, the present compositions comprise at least one component selected from the group consisting of epoxy-functional components and oxetane-functional components. Preferably, the compositions comprise, relative to the total weight of the composition, at least 20 wt% of cationically curable components, for instance at least 40 wt%, at least 60 wt%, at least 70 wt%, or at least 80 wt%. Generally, the compositions
25 comprise, relative to the total weight of the composition, less than 99 wt% of cationically curable components, for instance less than 95 wt%, less than 90 wt%, or less than 85 wt%.

(A1) *Epoxy-functional components*

The present compositions preferably comprise at least one epoxy-functional component, *e.g.*
30 an aromatic epoxy-functional component ("aromatic epoxy") and/or an aliphatic epoxy-functional component ("aliphatic epoxy"). Epoxy-functional components are components comprising one or more epoxy groups, *i.e.* one or more three-member ring structures (oxiranes) according to formula (1):



(1).

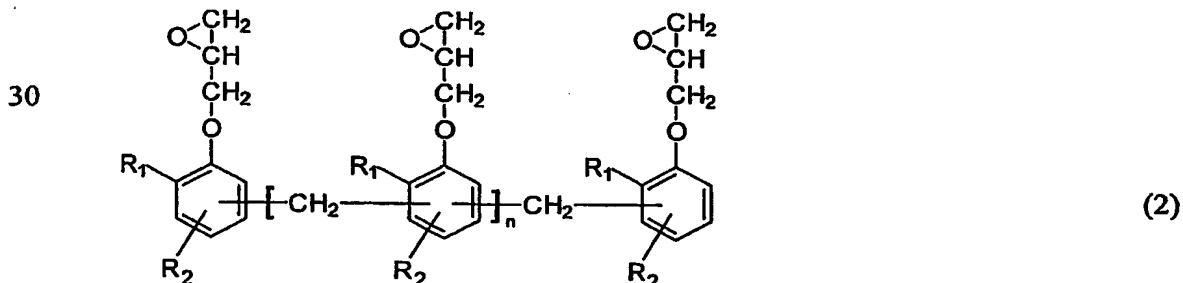
(A1-i) aromatic epoxies

- 5 Aromatic epoxies are components that comprise one or more epoxy groups and one or more aromatic rings. The compositions may comprise one or more aromatic epoxies, *e.g.* two or more aromatic epoxies or three or more aromatic epoxies.

10 Examples of aromatic epoxies include aromatic epoxies derived from a polyphenol, *e.g.* from bisphenols such as bisphenol A (4,4'-isopropylidenediphenol), bisphenol F (bis[4-hydroxyphenyl]methane), bisphenol S (4,4'-sulfonyldiphenol), 4,4'-cyclohexylidenebisphenol, 4,4'-biphenol, or 4,4'-(9-fluorenylidene)diphenol. The bisphenols may be alkoxyated (*e.g.* ethoxylated and/or propoxylated) and/or halogenated (*e.g.* brominated). Examples of bisphenol epoxies include bisphenol diglycidyl ethers.

15 Further examples of aromatic epoxies include triphenylolmethane triglycidyl ether, 1,1,1-tris(*p*-hydroxyphenyl)ethane triglycidyl ether, and aromatic epoxies derived from a monophenol, *e.g.* from resorcinol (for instance resorcin diglycidyl ether) or hydroquinone (for instance hydroquinone diglycidyl ether). Another example is nonylphenyl glycidyl ether.

20 In addition, examples of aromatic epoxies include epoxy novolacs, for instance phenol epoxy novolacs and cresol epoxy novolacs. Commercial examples of cresol epoxy novolacs include, *e.g.*, EPICLON N-660, N-665, N-667, N-670, N-673, N-680, N-690, and N-695, manufactured by Dainippon Ink and Chemicals, Inc. Examples of phenol epoxy novolacs
25 include, *e.g.*, EPICLON N-740, N-770, N-775, and N-865, manufactured by Dainippon Ink and Chemicals Inc. Examples of epoxy novolacs also include those components represented by the following formulae (2), (3), or (4):





R₁ represents a hydrogen atom or a methyl group;

20 n represents an integer of 1-12 (e.g. 2-12 or 1-5);

R₄ represents a hydrogen atom or an alkyl group having 1-3 atoms (e.g. a methyl-, ethyl-, or n-propyl group).

25

30

(A1-ii) aliphatic epoxies

Aliphatic epoxies are components that comprise one or more epoxy groups and are absent an aromatic ring. The compositions may comprise one or more aliphatic epoxies.

- 5 Examples of aliphatic epoxies include glycidyl ethers of C₂-C₃₀ alkyls; 1,2 epoxies of C₃-C₃₀ alkyls; mono and multi glycidyl ethers of aliphatic alcohols and polyols such as 1,4-butanediol, neopentyl glycol, cyclohexane dimethanol, dibromo neopentyl glycol, trimethylol propane, polytetramethylene oxide, polyethylene oxide, polypropylene oxide, glycerol, and alkoxyated aliphatic alcohols and polyols.

10

- In one embodiment, it is preferred that the aliphatic epoxies comprise one or more cycloaliphatic ring structures. For instance, the aliphatic epoxies may have one or more cyclohexene oxide structures, e.g. two cyclohexene oxide structures. Examples of aliphatic epoxies comprising a ring structure include hydrogenated bisphenol A diglycidyl ethers,
- 15 hydrogenated bisphenol F diglycidyl ethers, hydrogenated bisphenol S diglycidyl ethers, bis(4-hydroxycyclohexyl)methane diglycidyl ether, 2,2-bis(4-hydroxycyclohexyl)propane diglycidyl ether, 3,4-epoxycyclohexylmethyl-3,4-epoxycyclohexanecarboxylate, 3,4-epoxy-6-methylcyclohexylmethyl-3,4-epoxy-6-methylcyclohexanecarboxylate, di(3,4-epoxycyclohexylmethyl)hexanedioate, di(3,4-epoxy-6-
- 20 methylcyclohexylmethyl)hexanedioate, ethylenebis(3,4-epoxycyclohexanecarboxylate), ethanedioldi(3,4-epoxycyclohexylmethyl) ether, and 2-(3,4-epoxycyclohexyl-5,5-spiro-3,4-epoxy)cyclohexane-1,3-dioxane.

- Examples of aliphatic epoxies are also listed in U.S. Patent 6,410,127, which is hereby
- 25 incorporated in its entirety by reference.

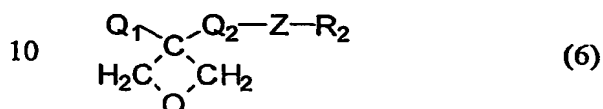
- In one embodiment, the present compositions comprise, relative to the total weight of the composition, at least 5 wt% of one or more aliphatic epoxies, for instance at least 8 wt%, at least 10wt%, or at least 12 wt%. Generally, the present compositions will comprise, relative
- 30 to the total weight of the composition, less than 50 wt% of aliphatic epoxies, for instance less than 40 wt%, less than 30 wt%, less than 25wt%, or less than 20 wt%.

(A2) Oxetane-functional components

The present compositions may comprise one or more oxetane-functional components ("oxetanes"). Oxetanes are components comprising one or more oxetane groups, *i.e.* one or more four-member ring structures according to formula (5):



Examples of oxetanes include components represented by the following formula (6):



wherein

- Q₁ represents a hydrogen atom, an alkyl group having 1 to 6 carbon atoms (such as a methyl, ethyl, propyl, or butyl group), a fluoroalkyl group having 1 to 6 carbon atoms, an allyl group, an aryl group, a furyl group, or a thienyl group;
- Q₂ represents an alkylene group having 1 to 6 carbon atoms (such as a methylene, ethylene, propylene, or butylene group), or an alkylene group containing an ether linkage, for example, an oxyalkylene group, such as an oxyethylene, oxypropylene, or oxybutylene group
- Z represents an oxygen atom or a sulphur atom; and
- R₂ represents a hydrogen atom, an alkyl group having 1-6 carbon atoms (e.g. a methyl group, ethyl group, propyl group, or butyl group), an alkenyl group having 2-6 carbon atoms (e.g. a 1-propenyl group, 2-propenyl group, 2-methyl-1-propenyl group, 2-methyl-2-propenyl group, 1-butenyl group, 2-butenyl group, or 3-butenyl group), an aryl group having 6-18 carbon atoms (e.g. a phenyl group, naphthyl group, anthranyl group, or phenanthryl group), a substituted or unsubstituted aralkyl group having 7-18 carbon atoms (e.g. a benzyl group, fluorobenzyl group, methoxy benzyl group, phenethyl group, styryl group, cinnamyl group, ethoxybenzyl group), an aryloxyalkyl group (e.g. a phenoxymethyl group or phenoxyethyl group), an alkylcarbonyl group having 2-6 carbon atoms (e.g. an ethylcarbonyl group, propylcarbonyl group, or butylcarbonyl group), an alkoxy carbonyl group having 2-6 carbon atoms (e.g. an ethoxycarbonyl group, propoxycarbonyl group, or butoxycarbonyl group), an N-alkylcarbamoyl group having 2-6 carbon atoms (e.g. an ethylcarbamoyl group, propylcarbamoyl group, butylcarbamoyl group, or pentylcarbamoyl group), or a polyethergroup having 2-1000 carbon atoms.

Preferred oxetanes include those wherein

Q₁ represents a C₁-C₄ alkyl group (*e.g.* an ethyl group),

Z represents an oxygen atom,

Q₂ represents a methylene group, and/or

- 5 R₂ represents a hydrogen atom, a C₁-C₈ alkyl group, or a phenyl group.

Some further examples of oxetanes include the following:

- Oxetanes containing one oxetane ring in the molecule include, for instance, 3-ethyl-3-
- 10 hydroxymethyloxetane, 3-(meth)allyloxymethyl-3-ethyloxetane, (3-ethyl-3-oxetanylmethoxy)methylbenzene, (3-ethyl-3-oxetanylmethoxy)benzene, 4-fluoro-[1-(3-ethyl-3-oxetanylmethoxy)methyl]benzene, 4-methoxy-[1-(3-ethyl-3-oxetanylmethoxy)methyl]benzene, [1-(3-ethyl-3-oxetanylmethoxy)ethyl] phenyl ether, isobutoxymethyl (3-ethyl-3-oxetanylmethyl) ether, isobornyloxyethyl (3-ethyl-3-
- 15 oxetanylmethyl) ether, isobornyl (3-ethyl-3-oxetanylmethyl) ether, 2-ethylhexyl (3-ethyl-3-oxetanyl methyl) ether, ethyldiethylene glycol (3-ethyl-3-oxetanylmethyl) ether, dicyclopentadiene (3-ethyl-3-oxetanylmethyl) ether, dicyclopentenyl (3-ethyl-3-oxetanyl methyl) ether, dicyclopentenyl (3-ethyl-3-oxetanylmethyl) ether, tetrahydrofurfuryl (3-ethyl-3-oxetanylmethyl) ether, tetrabromophenyl (3-ethyl-3-oxetanylmethyl) ether, 2-
- 20 tetrabromophenoxyethyl (3-ethyl-3-oxetanylmethyl) ether, tribromophenyl (3-ethyl-3-oxetanylmethyl) ether, 2-tribromophenoxyethyl (3-ethyl-3-oxetanylmethyl) ether, 2-hydroxyethyl (3-ethyl-3-oxetanyl methyl) ether, 2-hydroxypropyl (3-ethyl-3-oxetanylmethyl) ether, butoxyethyl (3-ethyl-3-oxetanylmethyl) ether, pentachlorophenyl (3-ethyl-3-oxetanylmethyl) ether, pentabromophenyl (3-ethyl-3-oxetanylmethyl) ether, bornyl (3-ethyl-
- 25 3-oxetanylmethyl) ether, 2-phenyl-3, 3-dimethyl-oxetane, and 2-(4-methoxyphenyl)-3, 3-dimethyl-oxetane.

- Oxetanes containing two or more oxetane rings in the molecule include, for instance, 3,7-bis(3-oxetanyl)-5-oxa-nonane, 3,3'-(1,3-(2-methylenyl)propanediylbis(oxymethylene))bis-(3-
- 30 ethyloxetane), 1,4-bis[(3-ethyl-3-oxetanylmethoxy)methyl]benzene, 1,2-bis[(3-ethyl-3-oxetanylmethoxy)methyl]ethane, 1,3-bis[(3-ethyl-3-oxetanylmethoxy)methyl]propane, ethylene glycol bis(3-ethyl-3-oxetanylmethyl) ether, dicyclopentenyl bis(3-ethyl-3-oxetanylmethyl) ether, triethylene glycol bis(3-ethyl-3-oxetanylmethyl) ether, tetraethylene glycol bis(3-ethyl-3-oxetanylmethyl) ether, tricyclodecanediyl dimethylene (3-ethyl-3-

oxetanylmethyl) ether, trimethylolpropane tris(3-ethyl-3-oxetanylmethyl) ether, 1,4-bis(3-ethyl-3-oxetanylmethoxy)butane, 1,6-bis(3-ethyl-3-oxetanylmethoxy)hexane, pentaerythritol tris(3-ethyl-3-oxetanylmethyl) ether, pentaerythritol tetrakis(3-ethyl-3-oxetanylmethyl) ether, polyethylene glycol bis(3-ethyl-3-oxetanylmethyl) ether, dipentaerythritol hexakis(3-ethyl-3-oxetanylmethyl) ether, dipentaerythritol pentakis(3-ethyl-3-oxetanylmethyl) ether, dipentaerythritol tetrakis(3-ethyl-3-oxetanylmethyl) ether, caprolactone-modified dipentaerythritol hexakis(3-ethyl-3-oxetanylmethyl) ether, caprolactone-modified dipentaerythritol pentakis(3-ethyl-3-oxetanylmethyl) ether, ditrimethylolpropane tetrakis(3-ethyl-3-oxetanylmethyl) ether, ethoxylated bisphenol A bis(3-ethyl-3-oxetanylmethyl) ether, propoxylated bisphenol A bis(3-ethyl-3-oxetanylmethyl) ether, ethoxylated hydrogenated bisphenol A bis(3-ethyl-3-oxetanylmethyl) ether, propoxylated hydrogenated bisphenol A bis(3-ethyl-3-oxetanylmethyl) ether, ethoxylated bisphenol F (3-ethyl-3-oxetanylmethyl) ether.

In one embodiment, the present compositions comprise, relative to the total weight of the composition, at least 5 wt% of one or more oxetanes, *e.g.* at least 8 wt%, at least 10 wt%, at least 12 wt%, or at least 14 wt%. Generally, the present compositions comprise less than 50 wt% of oxetanes, *e.g.* less than 40 wt%, less than 35 wt%, less than 30 wt%, or less than 25 wt%.

(B) Free radical polymerizable components

In addition to one or more cationically curable components, the present invention may comprise one or more free radical curable components, *e.g.* one or more free radical polymerizable components having one or more ethylenically unsaturated groups, such as (meth)acrylate (*i.e.* acrylate and/or methacrylate) functional components.

Examples of monofunctional ethylenically unsaturated components include acrylamide, N,N-dimethylacrylamide, (meth)acryloylmorpholine, 7-amino-3,7-dimethyloctyl (meth)acrylate, isobutoxymethyl(meth)acrylamide, isobornyloxyethyl (meth)acrylate, isobornyl (meth)acrylate, 2-ethylhexyl (meth)acrylate, ethyldiethylene glycol (meth)acrylate, t-octyl (meth)acrylamide, diacetone (meth)acrylamide, dimethylaminoethyl (meth)acrylate, diethylaminoethyl (meth)acrylate, lauryl (meth)acrylate, dicyclopentadiene (meth)acrylate, dicyclopentenyl (meth)acrylate, dicyclopentenyl (meth)acrylate, N,N-dimethyl(meth)acrylamidetetrachlorophenyl (meth)acrylate, 2-tetrachlorophenoxyethyl

- (meth)acrylate, tetrahydrofurfuryl (meth)acrylate, tetrabromophenyl (meth)acrylate, 2-tetrabromophenoxyethyl (meth)acrylate, 2-trichlorophenoxyethyl (meth)acrylate, tribromophenyl (meth)acrylate, 2-tribromophenoxyethyl (meth)acrylate, 2-hydroxyethyl (meth)acrylate, 2-hydroxypropyl (meth)acrylate, vinylcaprolactam, N-vinylpyrrolidone, phenoxyethyl (meth)acrylate, butoxyethyl (meth)acrylate, pentachlorophenyl (meth)acrylate, pentabromophenyl (meth)acrylate, polyethylene glycol mono(meth)acrylate, polypropylene glycol mono(meth)acrylate, bornyl (meth)acrylate, and, methyltriethylene diglycol (meth)acrylate.
- 10 Examples of the polyfunctional ethylenically unsaturated components include ethylene glycol di(meth)acrylate, dicyclopentenyl di(meth)acrylate, triethylene glycol diacrylate, tetraethylene glycol di(meth)acrylate, tricyclodecanedioldimethylene di(meth)acrylate, trimethylolpropane tri(meth)acrylate, ethoxylated trimethylolpropane tri(meth)acrylate, propoxylated trimethylolpropane tri(meth)acrylate, tripropylene glycol di(meth)acrylate,
- 15 neopentyl glycol di(meth)acrylate, both-terminal (meth)acrylic acid adduct of bisphenol A diglycidyl ether, 1,4-butanediol di(meth)acrylate, 1,6-hexanediol di(meth)acrylate, polyethylene glycol di(meth)acrylate, (meth)acrylate-functional pentaerythritol derivatives (e.g. pentaerythritol tri(meth)acrylate; pentaerythritol tetra(meth)acrylate, dipentaerythritol hexa(meth)acrylate, dipentaerythritol penta(meth)acrylate, or dipentaerythritol
- 20 tetra(meth)acrylate), ditrimethylolpropane tetra(meth)acrylate, ethoxylated bisphenol A di(meth)acrylate, propoxylated bisphenol A di(meth)acrylate, ethoxylated hydrogenated bisphenol A di(meth)acrylate, propoxylated -modified hydrogenated bisphenol A di(meth)acrylate, and ethoxylated bisphenol F di(meth)acrylate.
- 25 In one embodiment, the present compositions comprise one or more components having at least 3 (meth)acrylate groups, for instance 3-6 (meth)acrylate groups or 5-6 (meth)acrylate groups.
- If present, the compositions may comprise, relative to the total weight of the composition, at
- 30 least 3 wt% of one or more free radical polymerizable components, for instance at least 6 wt% or at least 9 wt%. Generally, the compositions comprise, relative to the total weight of the composition, less than 50 wt% of free radical polymerizable components, for instance less than 35 wt%, less than 25 wt%, less than 20 wt%, or less than 15 wt%.

(C) Hydroxy-functional components

Preliminarily, hydroxy-functional components in this section (C) are understood to be absent curable groups (such as, e.g., acrylate-, epoxy-, or oxetane groups) and to be not selected from the group consisting of photoinitiators.

5

The present compositions may comprise one or more hydroxy-functional components.

Hydroxy-functional components may be helpful in further tailoring mechanical properties of the present compositions upon cure. Hydroxy-functional components include monols (hydroxy-functional components comprising one hydroxy group) and polyols (hydroxy-

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Representative examples of hydroxy-functional components include alkanols, monoalkyl ethers of polyoxyalkyleneglycols, monoalkyl ethers of alkylene glycols, alkylene and arylalkylene glycols, such as 1,2,4-butanetriol, 1,2,6-hexanetriol, 1,2,3-heptanetriol, 2,6-dimethyl-1,2,6-hexanetriol, (2R,3R)-(-)-2-benzyloxy-1,3,4-butanetriol, 1,2,3-hexanetriol, 1,2,3-butanetriol, 3-methyl-1,3,5-pentanetriol, 1,2,3-cyclohexanetriol, 1,3,5-cyclohexanetriol, 3,7,11,15-tetramethyl-1,2,3-hexadecanetriol, 2-hydroxymethyltetrahydropyran-3,4,5-triol, 2,2,4,4-tetramethyl-1,3-cyclobutanediol, 1,3-cyclopentanediol, trans-1,2-cyclooctanediol, 1,16-hexadecanediol, 3,6-dithia-1,8-octanediol, 2-butyne-1,4-diol, 1,3-propanediol, 1,4-butanediol, 1,5-pentanediol, 1,6-hexanediol, 1,7-heptanediol, 1,8-octanediol, 1,9-nonanediol, 1-phenyl-1,2-ethanediol, 1,2-cyclohexanediol, 1,5-decalindiol, 2,5-dimethyl-3-hexyne-2,5-diol, 2,7-dimethyl-3,5-octadiyne-2,7-diol, 2,3-butanediol, 1,4-cyclohexanedimethanol, polyoxyethylene and polyoxypropylene glycols and triols of molecular weights from about 200 to about 10,000, polytetramethylene glycols of varying molecular weight, poly(oxyethylene-oxybutylene) random or block copolymers, copolymers containing pendant hydroxy groups formed by hydrolysis or partial hydrolysis of vinyl acetate copolymers, polyvinylacetal resins containing pendant hydroxyl groups; hydroxy-functional (e.g. hydroxy-terminated) polyesters and hydroxy-functional (e.g. hydroxy-terminated) polylactones, aliphatic polycarbonate polyols (e.g. an aliphatic polycarbonate diol), hydroxy-functional (e.g. hydroxy-terminated) polyethers (e.g. polytetrahydrofuran polyols having a number average molecular weight in the range of 150-4000 g/mol, 150-1500g/mol, or 150-750 g/mol), and combinations thereof.

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In one embodiment, the compositions are absent substantial amounts of hydroxy-functional components. The absence of substantial amounts of hydroxy-functional components may decrease the hygroscopicity of the compositions and/or articles obtained therewith. For instance, the compositions may comprise, relative to the total weight of the composition, less than 15 wt%, less than 10 wt%, less than 6 wt%, less than 4 wt%, less than 2 wt%, or about 0 wt% of hydroxy-functional components.

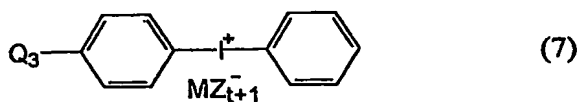
(D) Cationic photoinitiators

The present compositions preferably comprise one or more cationic photoinitiators, *i.e.* photoinitiators that, upon exposure to actinic radiation, form cations that can initiate the reactions of cationically polymerizable components, such as epoxies or oxetanes.

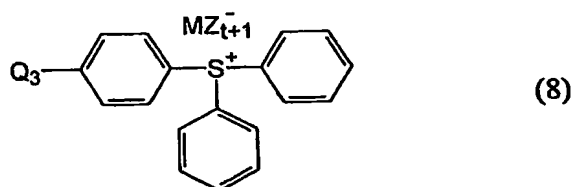
Examples of cationic photoinitiators include, for instance, onium salts with anions of weak nucleophilicity. Examples include halonium salts, iodosyl salts or sulfonium salts, such as are described in published European patent application EP 153904 and WO 98/28663, sulfoxonium salts, such as described, for example, in published European patent applications EP 35969, 44274, 54509, and 164314, or diazonium salts, such as described, for example, in U.S. Patents 3,708,296 and 5,002,856. All eight of these disclosures are hereby incorporated in their entirety by reference. Other examples of cationic photoinitiators include metallocene salts, such as described, for instance, in published European applications EP 94914 and 94915, which applications are both hereby incorporated in their entirety by reference.

In one embodiment, the present compositions comprise one or more photoinitiators represented by the following formula (7) or (8):

25



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wherein

Q₃ represents a hydrogen atom, an alkyl group having 1 to 18 carbon atoms, or an alkoxyl group having 1 to 18 carbon atoms;

M represents a metal atom, *e.g.* antimony;

Z represents a halogen atom, *e.g.* fluorine; and

5 t is the valent number of the metal, *e.g.* 5 in the case of antimony.

In one embodiment, the present compositions comprise, relative to the total weight of the composition, 0.1-15 wt% of one or more cationic photoinitiators, for instance 1-10 wt%.

10 (E) *Free radical photoinitiators*

The compositions may employ one or more free radical photoinitiators. Examples of free radical photoinitiators include benzophenones (*e.g.* benzophenone, alkyl-substituted benzophenone, or alkoxy-substituted benzophenone); benzoin, *e.g.* benzoin, benzoin ethers, such as benzoin methyl ether, benzoin ethyl ether, and benzoin isopropyl ether, benzoin

15 phenyl ether, and benzoin acetate; acetophenones, such as acetophenone, 2,2-dimethoxyacetophenone, 4-(phenylthio)acetophenone, and 1,1-dichloroacetophenone; benzil, benzil ketals, such as benzil dimethyl ketal, and benzil diethyl ketal; anthraquinones, such as 2-methylantraquinone, 2-ethylantraquinone, 2-tertbutylantraquinone, 1-chloroanthraquinone, and 2-amylantraquinone; triphenylphosphine; benzoylphosphine
20 oxides, such as, for example, 2,4,6-trimethylbenzoyldiphenylphosphine oxide; thioxanthenes and xanthenes, acridine derivatives, phenazine derivatives, quinoxaline derivatives or 1-phenyl-1,2-propanedione-2-O-benzoyloxime, 1-aminophenyl ketones or 1-hydroxyphenyl ketones, such as 1-hydroxycyclohexyl phenyl ketone, phenyl (1-hydroxyisopropyl)ketone and 4-isopropylphenyl(1-hydroxyisopropyl)ketone, or triazine compounds, for example, 4'''-
25 methyl thiophenyl-1-di(trichloromethyl)-3,5-S-triazine, S-triazine-2-(stilbene)-4,6-bistrichloromethyl, and paramethoxy styryl triazine.

Further suitable free radical photoinitiators include the ionic dye-counter ion compounds, which are capable of absorbing actinic rays and producing free radicals, which can initiate the
30 polymerization of the acrylates. *See*, for example, published European Patent Application 223587, and U.S. Patents 4,751,102, 4,772,530 and 4,772,541, all four of which are hereby incorporated in their entirety by reference.

In one embodiment, the present compositions comprise, relative to the total weight of the composition, 0.1-15 wt% of one or more free radical photoinitiators, for instance 1-10 wt%.

(F) Additives

- 5 Additives may also be present in the composition of the invention. Stabilizers are sometimes added to the compositions in order to prevent a viscosity build-up, for instance a viscosity build-up during usage in a solid imaging process. Preferred stabilizers include those described in U.S. Patent 5,665,792, the entire disclosure of which is hereby incorporated by reference. Such stabilizers are usually hydrocarbon carboxylic acid salts of group IA and IIA
- 10 metals. Most preferred examples of these salts are sodium bicarbonate, potassium bicarbonate, and rubidium carbonate. Alternative stabilizers are polyvinylpyrrolidones and polyacrylonitriles. Other possible additives are dyes, including dyes that change color upon cure. Examples of color-changing dyes include COPIKEM 20 (3,3-bis (1-butyl -2-methyl-H-indol-3-yl) - 1-(3H)-isobenzofuranone), COPIKEM 5 (2'-di (phenylmethy) amino-6'-
- 15 (diethylamino)spiro(isobenzofuran-1(3H),9'-(9H)xanthen)-3-one), COPIKEM 14 (a substituted phthalide), COPIKEM 7 (3-((4-dimethylamino)-phenyl)-3 -(1-butyl-2-methylindol-3-yl) -6-dimethyamino) -1(3H)-isobenzofuranone), and COPIKEM 37 (2-(2-octoxyphenyl)-4-(4-dimethylaminophenyl)-6-(phenyl)pyridine). If present, the amount of color-changing dyes in the compositions is, relative to the total weight of the composition,
- 20 preferably at least 0.0001 wt%, for instance at least 0.0005 wt%. In one embodiment, the amount of dye is, relative to the total weight of the composition, less than 1 wt%, *e.g.* less than 0.1 wt%. Even further examples of additives include antioxidants, wetting agents, antifoaming agents, thickening agents, photosensitizers (*e.g.* *n*-ethyl carbazole, benzoperylene, 1,8-diphenyl-1,3,5,7-octatetraene, or 1,6-diphenyl-1,3,5-hexatriene), and
- 25 metallic-, organic-, inorganic-, or organic-inorganic hybrid fillers (*e.g.* silica particles, glass beads, or talc). The size of the fillers may vary and can be, for instance, in the nanometer range or in the micrometer range. In one embodiment, the present compositions comprise, relative to the total weight of the composition, less than 20 wt% of fillers, *e.g.* less than 10 wt%, less than 5 wt%, or about 0 wt%. In another embodiment, the present compositions
- 30 comprise, relative to the total weight of the composition, up to 90 wt% of filler, *e.g.* 20-90 wt%, 40-90 wt%, or 60-90 wt%.

Physical parameters

The present compositions, after full cure, preferably have a heat deflection temperature ("HDT") under a pressure of 1.82 MPa (264 psi) of at least 105°C, for instance at least 110°C, at least 115°C, at least 120°C, or at least 125°C. The HDT (1.82 MPa) is generally
5 below 300°C.

The present compositions, after full cure, preferably have an elongation at break of at least 1.5%, for instance at least 2.0%, at least 2.5%, at least 3%, or at least 3.5%. The elongation at break is generally below 50%.

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The present compositions preferably have an E10 cure speed of less than 85 mJ/cm², for instance less than 80 mJ/cm², less than 70 mJ/cm², less than 60 mJ/cm², less than 55 mJ/cm², less than 50 mJ/cm², or less than 45 mJ/cm².

15 The physical condition of the present compositions may vary and can be, for instance, a liquid, a gel, a paste, or a solid. If the composition is a liquid, it preferably has a viscosity, at 30°C, of less than 1000 mPas, for instance less than 750 mPas, less than 650 mPas, less than 550 mPas, less than 450 mPas, or less than 350 mPas.

20 The present compositions, after full cure, preferably have a tensile strength of at least 35 MPa, for instance at least 40 MPa, at least 50 MPa, at least 60 MPa, or at least 70 MPa.

The present compositions, after full cure, preferably have a Young's modulus of at least 1500 MPa, for instance at least 2000 MPa, at least 2500 MPa, at least 2750 MPa, or at least 3000
25 MPa.

The present compositions, after full cure, preferably have a glass transition temperature (T_g) of at least 105°C, for instance at least 110°C, at least 120°C, at least 130°C, at least 140°C, or at least 150°C. The T_g is generally below 300°C.

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Applications

The present compositions may be used, for instance, as coating compositions or as compositions for preparing a three dimensional object by rapid prototyping. The compositions may be cured by heat or any suitable form of radiation, e.g. electron beam

radiation or actinic radiation, or mixtures thereof. For instance, the composition may first be cured to a certain extent by radiation and subsequently be post-cured by heat.

Rapid prototyping, sometimes also referred to as "solid imaging" or "stereolithography", concerns the imagewise curing of successive thin layers of a curable composition to form a three-dimensional object. *See, e.g.*, U.S. Patents 4,987,044; 5,014,207; 5,474,719; 5,476,748; and 5,707,780; which are all five hereby incorporated in their entirety by reference. A rapid prototyping process may for instance be described as:

- (1) coating a layer of a composition onto a surface;
- 10 (2) exposing said layer imagewise to actinic radiation to form an imaged cross-section;
- (3) coating a further layer of the composition onto said imaged cross-section;
- (4) exposing said further layer imagewise to actinic radiation to form an additional imaged cross-section;
- (5) repeating steps (3) and (4) a sufficient number of times in order to build up a three-
- 15 dimensional article;
- (6) optionally, post-curing the three-dimensional article.

The following examples are given as particular embodiments of the invention and to demonstrate the practice and advantages thereof. It is to be understood that the examples are given by way of illustration and are not intended to limit the specification or the claims that follow in any manner.

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EXAMPLES

Table 1: Glossary

| Commercial Name (Supplier) | Description |
|---------------------------------------------|--------------------------------------------------------------------------------|
| EPON 825 (Resolution Performance Products) | bisphenol A diglycidyl ether (aromatic epoxy) |
| EPICLON N-740 (Dainippon Ink & Chemical) | phenol epoxy novolac (aromatic epoxy) |
| HELOXY 64 (Resolution Performance Products) | nonylphenyl glycidyl ether (aromatic epoxy) |
| UVACURE 1500 (UCB Radcure) | 3,4-epoxy cyclohexyl methyl-3,4-epoxy cyclohexyl carboxylate (aliphatic epoxy) |
| UVR 6000 (Dow Chemical) | 3-ethyl-3-hydroxymethyl-oxetane (oxetane) |
| SR-399 (Sartomer) | monohydroxy dipentaerythritol pentaacrylate |
| IRGACURE 184 (Ciba Geigy) | 1-hydroxycyclohexyl phenyl ketone |
| DAROCURE 1173 (Ciba Geigy) | 2-hydroxy-2-methyl-1-phenyl-1-propanone |
| CPI-6976 (Aceto) | mixture of triarylsulfonium hexafluoroantimonate salts |
| SILWET L-7600 (OSI Specialities) | surfactant |
| BYK-A-501 (BYK-Chemie) | defoamer |
| PVP (Aldrich) | stabilizer (polyvinylpyrrolidone, Mw ca. 10,000) |

- 5 Compositions were prepared by mixing the components listed in Table 2 (Examples 1-8) and Table 3 (Comparative Examples A-B), with amounts of the components being listed in parts by weight. The thus prepared compositions were subsequently analyzed in accordance with the Test Methods described below. The test results are also listed in Tables 2 and 3.

Table 2: Examples 1-8

| Ingredients | Ex. 1 | Ex. 2 | Ex. 3 | Ex. 4 | Ex. 5 | Ex. 6 | Ex. 7 | Ex. 8 |
|--------------------------------|-------|-------|-------|-------|-------|-------|-------|-------|
| EPON 825 | 42 | 39 | 50 | 42.1 | 40.5 | 34.0 | 42.4 | 38.4 |
| EPICLON N-740 | 8 | 16 | | 13 | 12.5 | 13.4 | 12.3 | 17.5 |
| HELOXY 64 | | | | | 3.8 | | | |
| UVACURE 1500 | 12.5 | 12.5 | 12.5 | 12.5 | 12.0 | 20.2 | 12.5 | 13 |
| UVR 6000 | 20 | 15 | 20 | 15.5 | 15.5 | 15.5 | 16 | 16.6 |
| SR399 | 12 | 12 | 12 | 11 | 10.6 | 11.0 | 11 | 9.2 |
| CPI 6976 | 4 | 4 | 4 | 2.8 | 2.7 | 4 | 4 | 4 |
| IRGACURE 184 | 1.5 | 1.5 | 1.5 | 2.8 | 2.7 | 1.6 | | 1.6 |
| DAROCURE 1173 | | | | | | | 1.6 | |
| SILWET L-7600 | 0.2 | 0.2 | 0.2 | 0.2 | 0.2 | 0.2 | 0.2 | 0.2 |
| BYK A501 | 0.02 | 0.02 | 0.02 | 0.02 | 0.02 | 0.02 | 0.02 | 0.02 |
| PVP | 0.005 | 0.005 | 0.005 | 0.005 | 0.005 | | 0.005 | 0.005 |
| Test results | | | | | | | | |
| E_c [mJ/cm ²] | 10.3 | 8.4 | 6.8 | 8.7 | 9.9 | 5.2 | 9.6 | 7.8 |
| D_p [μm] | 130 | 117 | 137 | 140 | 152 | 112 | 130 | 122 |
| E_{10} [mJ/cm ²] | 73.4 | 73.6 | 44.3 | 53.5 | 51.8 | 49.9 | 68.9 | 61.8 |
| T_g [°C] | 129.8 | 151 | 118 | 132 | 127 | 135 | 131 | 127 |
| HDT (1.82 MPa) [°C] | 110.7 | 129.3 | 109 | 125.5 | 119.6 | | | |
| Young's modulus [MPa] | 3013 | 3131 | 3000 | 2951 | 3048 | 3083 | 3138 | 3000 |
| Elongation at break [%] | 3.7 | 2.6 | 3.5 | 3.3 | 3.7 | 2.3 | 2.0 | 1.7 |
| Tensile Strength [MPa] | 71.4 | 60.8 | 71.4 | 68.7 | 75.2 | 55.7 | 49.7 | 46.0 |
| Viscosity, 30°C [mPas] | 334 | 675 | 275 | 575 | 520 | 420 | 490 | |

Table 3: Comparative Examples A and B

| Ingredients | Comp. Ex. A | Comp. Ex. B |
|--------------------------------|-------------|-------------|
| EPON 825 | 49.6 | 52.8 |
| EPICLON N-740 | 16 | 16 |
| UVR 6000 | 16 | 16.6 |
| SR399 | 12 | 10.5 |
| CPI 6976 | 3.6 | 4 |
| IRGACURE 184 | 2.6 | 1.8 |
| DAROCURE 1173 | 0.2 | 0.2 |
| SILWET L-7600 | 0.02 | 0.02 |
| BYK A501 | 0.005 | 0.005 |
| Test results | | |
| E_c [mJ/cm ²] | 14.4 | 20.8 |
| D_p [μm] | 140 | 140 |
| E_{10} [mJ/cm ²] | 88.2 | 126.9 |
| T_g [°C] | 123 | 91 |
| Young's modulus [MPa] | 2979 | 3028 |
| Elongation at break [%] | 2.5 | 3.5 |
| Tensile Strength [MPa] | 59.6 | 71.6 |
| Viscosity, 30°C [mPas] | 850 | |

TEST METHODS

(a) Tensile Strength, Young's modulus, and Elongation at Break

Tensile data was obtained by testing tensile bars ("dogbones") made by first consecutively
5 imaging 150 μ m thick layers of the composition to be tested in a rapid prototyping machine. Each cross-sectional layer of the tensile bar was given exposure sufficient to polymerize the composition at a 250 μ m depth, providing approximately 100 μ m of overcure or engagement cure to assure adhesion to the previously coated and exposed layer. The layers were exposed with a laser emitting in the ultraviolet (UV) region at 354.7 nm. The resulting tensile
10 bars/dogbones were approximately 150 mm long and had a cross-section in the narrowed portion of approximately 1cm x 1cm. After preparation of the tensile bar in the rapid prototyping machine, the tensile bar was removed from the machine, washed with tri(propyleneglycol) methyl ether ("TPM") and isopropanol, and placed in a post-curing apparatus ("PCA" sold by 3-D Systems, 10 bulb unit using Phillips TLK/05 40W bulbs). In
15 the PCA, the tensile bar was post-cured first by subjecting it to 60 minutes of UV radiation at room temperature. After these 60 minutes, the UV radiation was stopped and the tensile bar was subjected to 160°C for two hours. The procedure of rapid prototyping a composition and post-curing a composition in the manner just described is understood herein to result in fully cured samples. The tensile tests to determine tensile strength, Young's modulus, and
20 elongation at break were run one day after preparation of the tensile bar and in accordance with ASTM D638, which is hereby incorporated in its entirety by reference, except that no provision was made for controlling the room temperature and humidity and the bars were not equilibrated for 2 days. The reported data is the average of three measurements.

(b) Viscosity

The composition was added to a 250-mL screw cap bottle and heated to 30°C by placing it in a 30°C bath for at least one hour. The viscosity of the composition was then determined with a Brookfield DV-II+ Viscometer employing a #3 spindle.

(c) Glass Transition Temperature (T_g)

30 A fully cured specimen was prepared in the same manner as described above for the preparation of a tensile bar. Part of the specimen was placed in a TA Instruments TMA 2940 at room temperature. The specimen was then heated with a ramp of 3°C/min from room temperature to 250°C under a nitrogen purge of 60 mL/min. A graph of dimension change

temperature to 250°C under a nitrogen purge of 60 mL/min. A graph of dimension change over temperature was generated and analyzed by using TA Instrument Universal Analysis V2.6D software, which calculated the glass transition temperature from a sudden change in the slope of the thermal expansion curve.

5

(d) Heat Deflection Temperature (HDT)

Fully cured specimens for determining the HDT were prepared in the same manner as the above tensile bars, except that the dimensions of the specimens for the HDT measurements were 5 inch (12.7 cm) in length and 0.5x0.5 inch (12.7mm x 12.7mm) in cross-section. The HDT (under a pressure of 1.82 MPa) of the specimens was then determined according to
 10 ASTM D648-00a Method B, which is hereby incorporated in its entirety by reference, employing an ATLAS HDV2 Automated instrument.

(e) E₁₀, D_p, and E_c

15 The photoproperties E_c (mJ/cm²), D_p (μm), and E₁₀ (mJ/cm²) represent the photoresponse (in this case thickness of layer formed) of a particular formulation to exposure by a single wavelength or range of wavelengths. In the instant Examples and Comparative Examples, at least 20 grams of composition was poured into a 100 mm diameter petri-dish and allowed to equilibrate to approximately 30°C and 30% RH. The samples were then scanned in a line-by-
 20 line fashion using a focused laser beam of approximately 100-140 mW. The laser, a frequency tripled YAG laser, had an output wavelength of 354.7 nm and was pulsed at 80 KHz. The exposures were made in a square pattern approximately 20 mm by 20 mm. Six individual exposures were made at near constant laser power but at various scan speeds. The parallel scan lines making up each exposure were drawn approximately 50 μm apart. Based
 25 upon knowledge of the diameter of the focused beam at the liquid surface, the scan speed, the laser power, and the scan spacing, the summation of exposure mJ/cm² was calculated. Each square was allowed to float on the surface of the petri-dish for approximately 15 minutes. Then the squares were blotted and a thickness measurement was taken using Mitutoyo NTO25-8"C spring loaded Absolute Digimatic calipers. When the natural log of the
 30 exposures is plotted against the measured thickness a least squares fit line can be drawn. The D_p (μm) is the slope of the least squares fit line. The E_c (mJ/cm²) is the X-axis crossing point (Y=0) of the line. And the E₁₀ is the energy necessary to produce a layer approximately 10 mils (254 μm) thick. In general, the lower the E₁₀ number, the faster the photospeed of the composition.

Having described specific embodiments of the present invention, it will be understood that many modifications thereof will readily be apparent to those skilled in the art, and it is intended therefore that this invention is limited only by the spirit and scope of the following

5 claims.

CLAIMS

What is claimed is:

- 5 1. A curable rapid prototyping composition comprising:
- (i) one or more aromatic epoxies; and
 - (ii) one or more aliphatic epoxies;
- wherein said composition, after full cure, has a heat deflection temperature (1.82 MPa) of at least 105°C and an elongation at break of at least 1.5%.
- 10 2. The composition of claim 1, wherein said composition comprises two or more aromatic epoxies.
- 15 3. The composition according to any one of claims 1-2, wherein said composition comprises at least 25 wt%, relative to the total weight of the composition, of said one or more aromatic epoxies.
- 20 4. The composition according to any one of claims 1-2, wherein said composition comprises at least 50 wt%, relative to the total weight of the composition, of said one or more aromatic epoxies.
5. The composition according to any one of claims 1-4, wherein said composition further comprises one or more oxetanes.
- 25 6. The composition according to claim 5, wherein said composition comprises 5-40 wt%, relative to the total weight of the composition, of said one or more oxetanes.
7. The composition according to any one of claims 1-6, wherein said one or more aliphatic epoxies consist essentially of epoxies comprising a cycloaliphatic ring structure.
- 30 8. The composition according to any one of claims 1-7, wherein said one or more aliphatic epoxies include an epoxy comprising two cyclohexene oxide structures.

9. The composition according to any one of claims 1-8, wherein said composition comprises 5-30 wt% of said one or more aliphatic epoxies.
10. The composition according to any one of claims 1-9, wherein said composition
5 comprises an epoxy having no more than one epoxy group.
11. The composition according to any one of claims 1-10, wherein said composition further comprises one or more free radical polymerizable components.
- 10 12. The composition of claim 11, wherein said one or more free radical polymerizable components include a component having 5 or 6 (meth)acrylate groups.
13. The composition according to any one of claims 11-12, wherein said composition comprises 5-25 wt%, relative to the total weight of the composition, of said one or more free
15 radical polymerizable component.
14. The composition according to any one of claims 1-13, wherein said one or more aromatic epoxies include a phenol epoxy novolac and/or a cresol epoxy novolac.
- 20 15. The composition according to any one of claims 1-14, wherein said one or more aromatic epoxies includes a bisphenol diglycidyl ether.
16. The composition according to any one of claims 1-15, wherein said composition comprises a (meth)acrylate functional pentaerythritol derivative.
25
17. The composition according to any one of claims 1-16, wherein said composition further comprises a cationic photoinitiator and a free radical photoinitiator.
18. The composition according to any one of claims 1-17, wherein said composition
30 comprises about 0-4 wt% of hydroxy-functional components that are absent a curable group and are not selected from the group consisting of photoinitiators.
19. The composition according to any one of claims 1-18, wherein said heat deflection temperature is at least 115°C.

20. The composition according to any one of claims 1-18, wherein said heat deflection temperature is at least 125°C.

5 21. The composition according to any one of claims 1-20, wherein said elongation to break is at least 2%.

22. The composition according to any one of claims 1-20, wherein said elongation to break is at least 3%.

10

23. The composition according to any one of claims 1-22, wherein said composition has an E10 cure speed of less than 80 mJ/cm².

15 24. The composition according to any one of claims 1-23, wherein said composition has a viscosity of less than 750 mPas at 30°C.

25. The composition according to any one of claims 1-24, wherein said composition, after full cure, has a tensile strength of at least 35 MPa.

20 26. The composition according to any one of claims, wherein said composition, after full cure, has a modulus of at least 2000 MPa.

27. The composition according to any one of claims 1-26, wherein said composition comprises a color-changing dye.

25

28. A curable composition having an E10 cure speed of less than 80 mJ/cm² and, after cure by radiation and heat, a heat deflection temperature (1.82 MPa) of at least 125°C and an elongation at break of at least 2.5%.

30 29. The composition according to any one of claims 1-28, wherein said composition comprises, relative to the total weight of the composition, about 0 wt% filler.

30. A rapid prototyping process comprising:

- (1) coating a layer of a composition according to any one of claims 1-29 onto a surface;
- (2) exposing said layer imagewise to actinic radiation to form an imaged cross-section;
- (3) coating a layer of said composition according to any one of claims 1-29 onto the previously exposed imaged cross-section;
- (4) exposing said layer from step (3) imagewise to actinic radiation to form an additional imaged cross-section;
- (5) repeating steps (3) and (4) a sufficient number of times to form a three-dimensional article.

31. An article obtainable by the process of claim 30.

ABSTRACT

The present invention provides curable compositions and rapid prototyping processes using the same. In one embodiment, the present compositions include one or more aromatic epoxies and one or more aliphatic epoxies, and, after full cure, exhibit a heat deflection
5 temperature of at least 105°C and an elongation at break of at least 1.5%.

PCT

INTERNATIONAL PRELIMINARY EXAMINATION REPORT

(PCT Article 36 and Rule 70)

REC'D 19 JAN 2005

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|-------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------|----------------------------------------------|
| Applicant's or agent's file reference 20890WO | FOR FURTHER ACTION See Notification of Transmittal of International Preliminary Examination Report (Form PCT/PEAA16) | |
| International application No. PCT/NL 03/00702 | International filing date (day/month/year) 16.10.2003 | Priority date (day/month/year) 18.10.2002 |
| International Patent Classification (IPC) or both national classification and IPC C08F283/10 | | |
| Applicant DSM IP ASSETS B.V. | | |

- This international preliminary examination report has been prepared by this International Preliminary Examining Authority and is transmitted to the applicant according to Article 36.
- This REPORT consists of a total of 5 sheets, including this cover sheet.

☐ This report is also accompanied by ANNEXES, i.e. sheets of the description, claims and/or drawings which have been amended and are the basis for this report and/or sheets containing rectifications made before this Authority (see Rule 70.16 and Section 607 of the Administrative Instructions under the PCT).

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- This report contains indications relating to the following items:
 - ☒ Basis of the opinion
 - ☐ Priority
 - ☐ Non-establishment of opinion with regard to novelty, inventive step and industrial applicability
 - ☐ Lack of unity of invention
 - ☒ Reasoned statement under Rule 66.2(a)(ii) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement
 - ☐ Certain documents cited
 - ☐ Certain defects in the international application
 - ☐ Certain observations on the international application

| | |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Date of submission of the demand 10.05.2004 | Date of completion of this report 20.01.2005 |
| Name and mailing address of the international preliminary examining authority:  European Patent Office - P.B. 5818 Patentlaan 2 NL-2280 HV Rijswijk - Pays Bas Tel. +31 70 340 - 2040 Tx: 31 651 epo nl Fax: +31 70 340 - 3016 | Authorized Officer Hammond, A Telephone No. +31 70 340-4253  |

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT**

International application No. **PCT/NL 03/00702**

I. Basis of the report

1. With regard to the **elements** of the international application (*Replacement sheets which have been furnished to the receiving Office in response to an invitation under Article 14 are referred to in this report as "originally filed" and are not annexed to this report since they do not contain amendments (Rules 70.16 and 70.17)*):

Description, Pages

1-20 as originally filed

Claims, Numbers

1-34 as originally filed

2. With regard to the **language**, all the elements marked above were available or furnished to this Authority in the language in which the international application was filed, unless otherwise indicated under this item.

These elements were available or furnished to this Authority in the following language: , which is:

- ☐ the language of a translation furnished for the purposes of the international search (under Rule 23.1(b)).
☐ the language of publication of the international application (under Rule 48.3(b)).
☐ the language of a translation furnished for the purposes of international preliminary examination (under Rule 55.2 and/or 55.3).

3. With regard to any **nucleotide and/or amino acid sequence** disclosed in the international application, the international preliminary examination was carried out on the basis of the sequence listing:

- ☐ contained in the international application in written form.
☐ filed together with the international application in computer readable form.
☐ furnished subsequently to this Authority in written form.
☐ furnished subsequently to this Authority in computer readable form.
☐ The statement that the subsequently furnished written sequence listing does not go beyond the disclosure in the international application as filed has been furnished.
☐ The statement that the information recorded in computer readable form is identical to the written sequence listing has been furnished.

4. The amendments have resulted in the cancellation of:

- ☐ the description, pages:
☐ the claims, Nos.:
☐ the drawings, sheets:

5. ☐ This report has been established as if (some of) the amendments had not been made, since they have been considered to go beyond the disclosure as filed (Rule 70.2(c)).

(Any replacement sheet containing such amendments must be referred to under item 1 and annexed to this report.)

6. Additional observations, if necessary:

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT**

International application No. PCT/NL 03/00702

**V. Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability;
citations and explanations supporting such statement**

1. Statement

| | | |
|-------------------------------|-------------|-------------|
| Novelty (N) | Yes: Claims | |
| | No: Claims | 1-4,7-34 NO |
| Inventive step (IS) | Yes: Claims | |
| | No: Claims | 1-34 NO |
| Industrial applicability (IA) | Yes: Claims | 1-34 YES |
| | No: Claims | |

2. Citations and explanations

see separate sheet

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT - SEPARATE SHEET**

International application No. PCT/NL 03/00702

Re Item I

Basis of the opinion

1. The present opinion is based on the claims 1-34 as filed.

Re Item V

Reasoned statement under Rule 66.2(a)(ii) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement

1. The following documents are cited in the present opinion. The numbering will be adhered to during the rest of the proceedings :

D1 WO9742549

D2 US5707780

D3 EP0848294

2. D1 discloses a curable rapid prototyping composition comprising (i) one or more aromatic epoxies, and (ii) one or more aliphatic epoxies.

The disclosures of D1 (abstract ; claims 1-4,11 ; page 5, line 15 - page 7, line 35 ; page 2, line 29 - page 4, line 13 ; examples I - IV ; examples ; page 8, line 1 - page 16, line 35 ; claims 12-14) appear to be novelty-attacking for the subject-matter of the present claims 1-4,7-34 (Article 33(2) PCT) in consideration of Guidelines, C, III, 4.7a for the physical parameter measurements.

The disclosures of D2 (abstract ; claims 1,2 ; column 4, line 54-58, 61-67 ; column 5, line 5-8 ; column 3, line 1 - column 9, line 63) appear to be novelty-attacking for the subject-matter of the present claims 1,3,4,7,9-11,13,14,,17,19-26,28-34 (Article 33(2) PCT) in consideration of Guidelines, C, III, 4.7a for the physical parameter measurements.

3. The difference between D1 (references as above) and the application claims 5-6 seems to be the clear disclosure that D1's compositions based on epoxies and other components such as ether acrylates etc. comprise an oxetane ether functional component.

The technical objective of the present application and D1 seems to be the same and relates to curable rapid prototyping compositions comprising aromatic epoxies and aliphatic epoxies. In consideration of the teachings throughout D1 that the said curable rapid prototyping epoxy compositions may comprise various further ether components (e.g. examples ; various ethers on pages 10-13 etc.), and the present lack of any clear comparative examples between D1 and the present application showing any unexpected /

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT - SEPARATE SHEET**

International application No. PCT/NL 03/00702

special effects in the use of oxetane ether components, the technical problem of the present application claims 5-6 in view of D1 can be defined as an alternative curable rapid prototyping composition.

The solution was the use of an oxetane ether functional component.

The use of oxetane ether functional components in such curable compositions comprising mixtures of epoxies is known per se to the man skilled in the art, for example D3 (abstract ; claims 1, 6 ; page 10, line 1 ; page 3, line 25 - page 15, line 16), and thus the substitution of one known ether functional component for another known ether functional component is considered to be a small variation for the man skilled in the art in order to solve the technical problem as defined above.

Therefore, the subject-matter of the present claims 5,6 appears not to involve an inventive step (Article 33(3) PCT).